

Date: Monday, 12/01/2009 2:36:55 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPAD
<b>Job Number</b> : 44656	
<b>Estimate Number</b> : 12785	
<b>P.O. Number</b> :	<b>Part Number</b> : D356411
<b>This Issue</b> : 12/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3564 REVD
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 43707	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 26/01/2009 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JD 09.01.13</u>	
<b>Comment</b> : Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 Sheet .063
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**Comment:** Qty.: 1.4805 sf(s)/Unit Total : 29.6100 sf(s)  
 M304S16GA Stainless steel sheet 0.063" thick  
 Batch: 110551 IB 9-1-28

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\*  
 Dwg Rev: D IB 9-1-28  
 Prog Rev: D

(20)

2-Deburr if necessary IB 9-1-28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

8 09/01/29 (470) counts

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 Deburr if necessary  
 Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 N/A

SD 09/01/30 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:36:55 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 44656

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*70501.30 (20)*



*(PTC)*

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

*11109893*

Weld hardcoat as per Dwg D3437

*EL 92-4 (X20)*

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*S 09/02/05 (X20)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 09/02/05 counted (X20)*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*M 104648*

START TIME:

*15:50*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*16:20*

*BL 09-02-05 (20)*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FR 09/02/06 (20)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *EP-19*

*UMD/EL 09/02/06 (20)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.01.30	5.0 6.0	No joggle required in -11 wearplates. remove DTB/SS & joggle note. perm change		09.02.06				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:36:55 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 44656

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/06 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 09-02-06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 44050
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3564-11
<b>Inspection Dwg:</b> D3564	<b>Rev:</b> D	<b>Page 1 of 1</b>

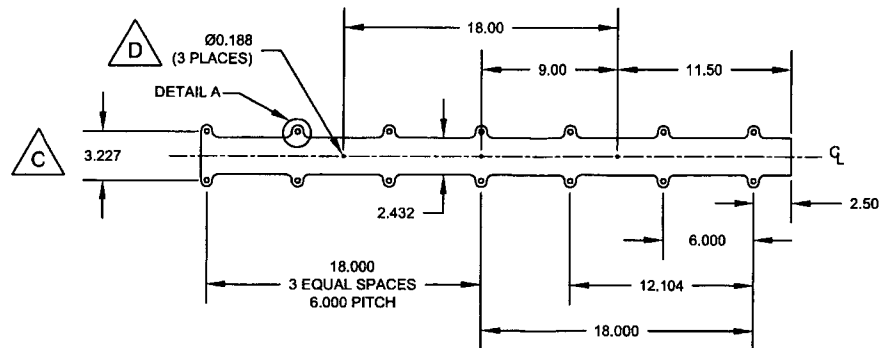
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

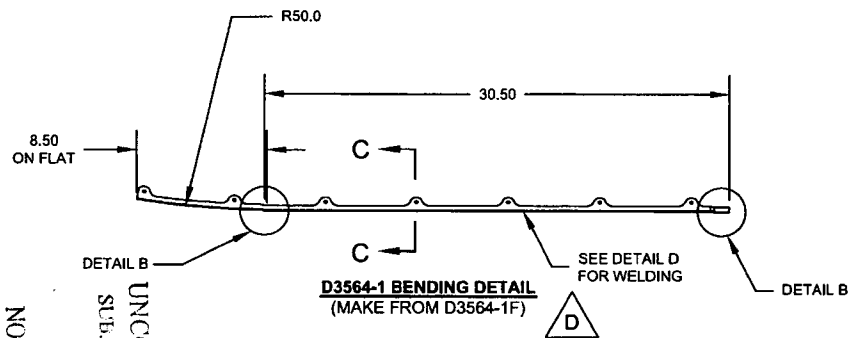
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.226	X			
2.432	+/-0.010	2.439	X			
2.50	+/-0.030	2.502	X			
6.000	+/-0.010	6.000	X			
12.104	+/-0.010	12.104	X			
18.000	+/-0.010	18.000	X			
18.00	+/-0.030	18.000	X			
9.00	+/-0.030	8.998	X			
11.50	+/-0.030	11.509	X			
0.300 x 0.300	+/-0.010	304x307	X			
Ø0.188	+0.005/-0.001	.192	X			
R0.375	+/-0.010	.375	X			
0.063	+/-0.010	.060	X			

<b>Measured by:</b> LB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-1-08	<b>Date:</b> 09/01/09	<b>Date:</b>	N/A

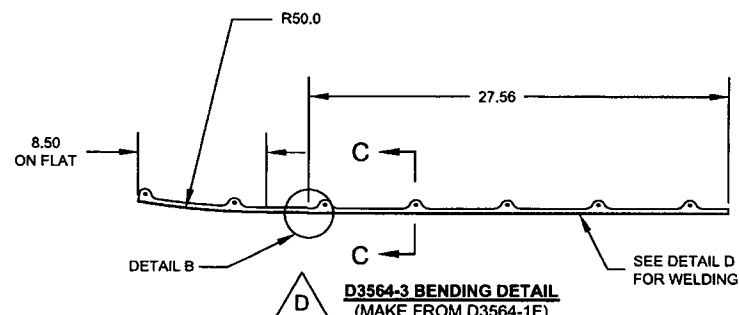
Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	



**D3564-1F FLAT PATTERN**



**D3564-1 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)

SHIP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
NO. 11111111

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT  $\bar{C}$

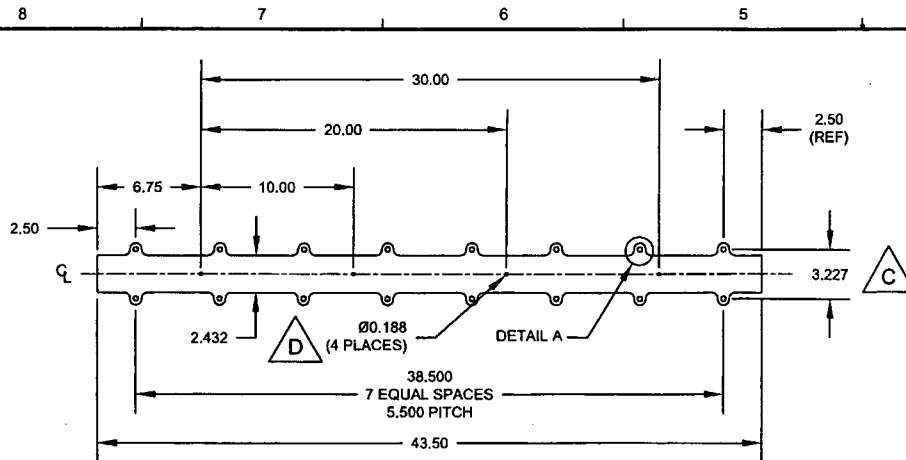
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

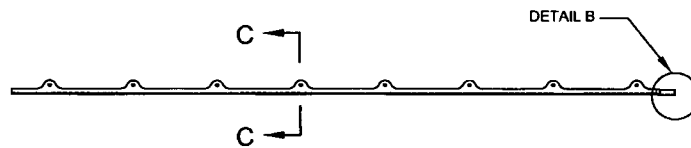
DART AEROSPACE LTD			
HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.	D3564	REV. D	
TITLE	WEARSHOE	SCALE	1:8
SHEET 1 OF 3			

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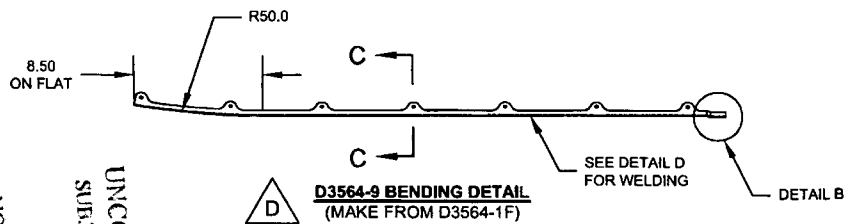




**D3564-5F FLAT PATTERN**

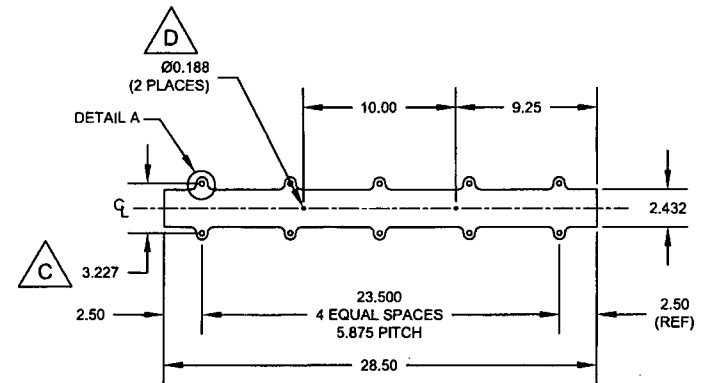


**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)

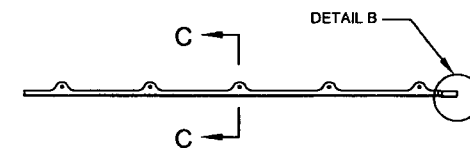


**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)

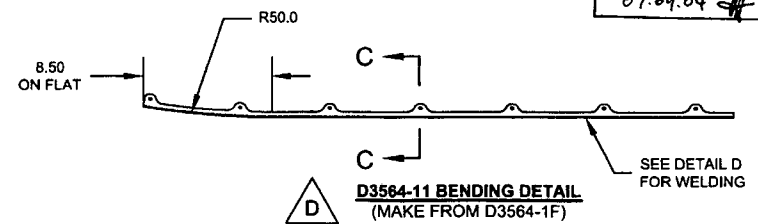
STOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 444850



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

RELEASED  
07.09.04

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**RELEASED**

07.09.04



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DRAWN	CB		SHEET 3 OF 3
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DE APPR.	PH		1:
DATE	07.08.21		